Work Order ID 68904

Monday, April 25, 2011 10:51:56 AM

Item ID: D2565-111 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Strut

Start Date: 4/25/2011 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 4/29/2011 **Req'd Qty:** 10.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** M **Date:** 11-04-25 **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2565	Rev E								
100	Punch ends and deburr as per dwg	0.00							
	NC BRAKE								
Brake NC	**Memo**	0.00							
Brake NC	Punch as per Dwg D2565 using DT 8313								
110		0.00							
	Small Fab								
Small Fab	**Memo**	0.00							
Small Fab	Deburr								
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									

SB 11/05/18

11/05/18 (10)

11.05.18 (10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel M116964.	0.00				10		11-5-18	
Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: 2:25 OVEN TEMPERATURE: 400 FINISH TIME: 2:55								
140	QC3- Inspect Part Finish	0.00				10		11/05/18	
QC	**Memo**	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: Z70	0.00						11/5/18	
Packaging	**Memo**	0.00							
Packaging									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 68904

Monday, April 25, 2011 10:51:56 AM

Item ID: D2565-111 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Strut

Start Date: 4/25/2011 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 4/29/2011 **Req'd Qty:** 10.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							11/5/19
QC	**Memo**	0.00							
Quality Control									MF 11-05-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Monday, April 25, 2011 10:52:02 AM

Work Order ID: 68904

Parent Item: D2565-111

Parent Item Name: Strut

Start Date: 4/25/2011 **Required Date:** 4/29/2011

Start Qty: 10.00 **Required Qty:** 10.00

Comments: IPP: E□01.06.04□Added Powder Coat, Removed Polish, and Added Inspection Levels 3 & 21□ EC
IPP: E□06.05.03 Change level 2/8 to QC5 EC□□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	67.0086	1.1375	11.97368			
304 RD Tube .750 x .049W										50 11/05/16			10

Location	Loc Qty	Loc Code	
MAT017	67.00863		
109314	9.333		
111619	3		
112187	4		
112800	11		
114852	2.75		
116108	3		
116720	1.833		
117030	32.09263		16

A17598

2

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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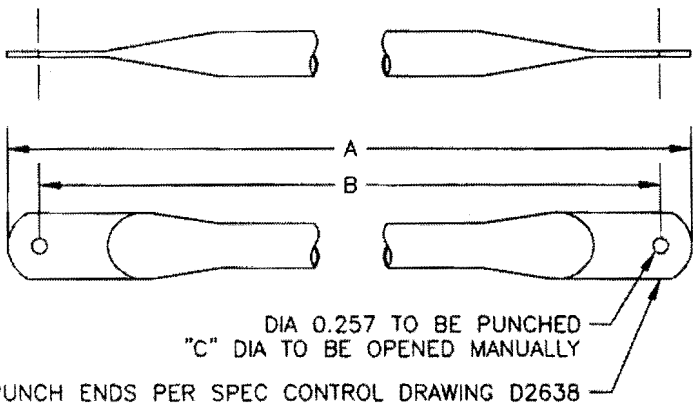
NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT	SCALE 1:3

A	96.05.03	NEW ISSUE
B	97.03.15	CORRECT D2565-111 DIM. A
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)
D	02.06.05	ADD -3XX PARTS; ADD FINISH
E	04.05.05	ADD D2565-401-411; RMV ANGLE D

RELEASED
04.05.05

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68907 04-04-25



PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	–
D2565-109	12.31	11.51	–
D2565-111	13.65	12.85	–
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	–
D2565-209	15.16	14.36	–
D2565-211	14.14	13.34	–
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	–
D2565-309	20.17	19.37	–
D2565-311	16.30	15.50	–
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	–
D2565-409	9.34	8.54	–
D2565-411	13.81	13.01	–

GENERAL NOTES
1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES

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Dart Aerospace Ltd

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